

# Work Order ID 61568

Monday, August 30, 2010 11:24:20 AM

Page 1

Item ID: D350-636-012

Accept

Revision ID:

Item Name: Skidtube RH

Start Date: 8/30/2010 Start Qty: 1.00

Required Date: 9/6/2010 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: *[Signature]*

Date: *10-8-31*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00

DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 005

*HA for BG 10-9-23*

BG 1568

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
	Skidtubes								
Skidtubes	<b>Memo</b> 1- Pick D2600-3 Bent  2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750  3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.  4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting  5- Drill fwd step holes using DT9616. Ensure proper positioning.  6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B) ***ONLY DRILL ONE SIDE OF FWD SADDLE HOLES USING DT8150***  7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***  8- Clecko DT9642 and drill fwd saddle holes on second side, ensure proper positioning.  9- Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)  10- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to	0.00							

10-9-2

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.297".

11-Open up holes of Detail A to 0.297" (total of 2 holes per side)

> DP 10-9-2

12-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: ☐ M114877 JE 10-02-02

13-Grind welds flush as per Dwg D2750

SAD 10-09-02 BB 10/9/14

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

1003-03

1003-03

**Dart Aerospace Ltd**

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Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

DP 10-9-7

Memo

0.00

Hand Finishing

150



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

BE (A) 10/09/07

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Skidtubes

Skidtubes

0.00

Memo

0.00

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐ Sikaflex-291batch: M115114 ☐ ☐

exp. date: 11-130

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 9)

A/R ☐ Aluminum Rod

batch: M114877

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

DP 10-9-7

DP 10-9-9

BE 10-9-14

BE 10-9-14

BE 10-9-14

BE 10-9-14

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Stop

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Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

dwg D2750

12-Deburr holes

BE 10-9-14

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S. Soler

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S. Soler

(XO)

**Dart Aerospace Ltd**

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Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
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DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Pressure Wash per QSI005 4.3

0.00

=) MU

10/09/15

1

Ø

HandFinish

Memo

0.00

Hand Finishing

✓ Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

A1114841

=) MU

10/09/15

1

Ø

Powdercoat

Memo

0.00

Powder Coating

START TIME: 12:45pm  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 1:15pm

210

QC3- Inspect Part Finish

0.00

BL 10-9-22

Ø

Ø

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

W/O:		WORK ORDER CHANGES					
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Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220

0.00 =&gt; M 10/09/22



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

✓ Install inserts as per dwg D2750

1	0		
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230

0.00 =&gt; M 10/09/22



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3"  
batch: U/A3-Install blade fitting D3488-042, wearshoes and ground handling hardware as  
per dwg D2750✓ SIKA FLEX 241  
BATCH: 11115114  
EXP DATE: 11/06✓ 4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube  
A/R 55-o-ring lube batch: 11114189✓ 5-Coat all exposed fasteners with "LPS Procyon"  
batch: 1111596

1	0		
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**Dart Aerospace Ltd**

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Run Start

Stop

Sequence ID/  
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Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.10.10/22

(H)

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

8.10.10/23

(L)

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8.10.10/23

(H)

W/O:		WORK ORDER CHANGES					
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Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

270

0.00



Packaging

Packaging

hce78

Reoth

Memo

0.00

Packaging

Package as per PPP D350-636-012

Cud/27 ①

280

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/09/27  
mf  
10-9-27

**Dart Aerospace Ltd**

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Required Date: 9/6/2010


Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC  
 IPP Rev: M 08-04-22 update steps 4,13 DD verified by: EC  
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec IPP Rev: O  
 10.06.22 revise seq 110 DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS4-1032-225		Purchased	No			220	Each	5,418.000	38	38			
<div style="display: flex; justify-content: space-between;"> <div>  <p>Insert</p> </div> <div> <p>Location</p> <p>PK011</p> <p>110768</p> </div> <div> <p>Loc Qty</p> <p>5418</p> <p>5418</p> </div> <div> <p>Loc Code</p> <p></p> </div> </div>													

AN3C5A		Purchased	No			230	Each	1,072.000	34	34			
<div style="display: flex; justify-content: space-between;"> <div>  <p>Bolt</p> </div> <div> <p>Location</p> <p>ST350</p> <p>114330</p> <p>115015</p> <p>115108</p> <p>115316</p> <p>115371</p> <p>115422</p> <p>ST351</p> <p>113121</p> </div> <div> <p>Loc Qty</p> <p>1062</p> <p>11</p> <p>251</p> <p>300</p> <p>300</p> <p>100</p> <p>100</p> <p>10</p> <p>10</p> </div> <div> <p>Loc Code</p> <p></p> </div> </div>													

9/10/09/22

X38

9/10/09/22

X34

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Required Date: 9/6/2010

Start Qty: 1.00

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AN3C6A Purchased No 230 Each 353.0000 4 4  
BOLT  
ST351 353  
111982 353  
129.0000 4 4  
y4 10/09/22

AN6C44A Purchased No 230 Each 129.0000 4 4  
BOLT  
ST344 127  
111649 2  
114653 1  
114941 75  
115030 49  
41.0000 1 1  
y4 10/09/22

AN8C35A Purchased No 230 Each 41.0000 1 1  
BOLT  
FP 1  
110847 1  
ST346 40  
114442 15  
115188 25  
y4 10/09/22

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 3

Work Order ID: 61568

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

NAS1149C0332  
R

Purchased

No

230

Each

155.0000

38

38



washer

M115698



x38 M 10/09/22

## Location

## Loc Qty

## Loc Code

ST245

155

107534

29

109545

54

111548

72

AN960C816L

Purchased

No

230

Each

0.0000

1

1



\* WASHER

D2745

Manufactured

No

230

Each

173.0000

8

8



Bushing

## Location

## Loc Qty

## Loc Code

ST023

173

52311

5

(59112)

68

61203

100

D3488-042

Manufactured

No

230

Each

13.0000

1

1



Blade Fitting Assembly, RH

## Location

## Loc Qty

## Loc Code

FP008

13

53918

1

(59643)

12

XL

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Page 3

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 4

Work Order ID: 61568

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3492-041 Manufactured No

230

Each

57.0000

8

8



Plug Assembly \* D34921 / B48274



x8 JH 10/09/27

Location

Loc Qty

Loc Code

FP013

57

59114

1

61311

56

D3492-043 Manufactured No

230

Each

23.0000

8

8



Plug Assembly



JH 10/09/22

Location

Loc Qty

Loc Code

FP

2

54682

2

FP013

21

59117

1

59190

4

61207

16

B61503

x8

D3535-25 Manufactured No

230

Each

10.0000

1

1



Wearshoe



JH 10/09/22

Location

Loc Qty

Loc Code

FP18

10

59623

10

B61706

x1

D3536-25 Manufactured No

230

Each

11.0000

1

1



Gasket



JH 10/09/22

Location

Loc Qty

Loc Code

FP12

11

59625

11

B61707

x1

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 5

Work Order ID: 61568

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

8.0000

3

3



Wearpad



HL 10/09/22

Location

Loc Qty

Loc Code

FP

1

B61640

X3

55465

1

FP017

48

FP17

7

57713

3

60491

4

D3631-1

Manufactured No

230

Each

475.0000

8

8



Washer



HL 10/09/22

Location

Loc Qty

Loc Code

ST072

201

60755

201

X8

ST076

274

52693

206

54388

68

D3672-1

Manufactured No

230

Each

921.0000

4

4



Phenolic Washer



HL 10/09/22

Location

Loc Qty

Loc Code

ST077

921

42329

150

52505

771

V4

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 6

Work Order ID: 61568

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

9.0000

1

1



Wearplate

Location

Loc Qty

Loc Code

FP17

9

B61704

X1

58573

8

59626

1

D3793-1

Manufactured No

230

Each

15.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP18

15

59151

1

59630

2

61244

12

D3793-3

Manufactured No

230

Each

14.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP18

13

59631

1

61258

12

FP19

1

57947

1

D3794-1

Manufactured No

230

Each

7.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP010

7

B61704

X1

57942

7

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 61568

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

12.0000

1



Gasket



1  
JH 10/09/22

Location

Loc Qty

Loc Code

FP10

1

60826

1

FP18

11

56066

10

59153

1

X1

MS21043-6

Purchased

No

230

Each

678.0000

4



NUT



4  
JH 10/09/22

Location

Loc Qty

Loc Code

ST301

678

112314

678

X4

MS21083C8

Purchased

No

230

Each

30.0000

1



NUT



1  
JH 10/09/22

Location

Loc Qty

Loc Code

ST303

30

113845

7

114934

23

X1

NAS1611-010

Purchased

No

230

Each

259.0000

8



O-RING



8  
JH 10/09/22 PTO =>

Location

Loc Qty

Loc Code

FP

259

110715

100

110915

159

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Dart Aerospace Ltd

W/O: 61568		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/09/22	230	Replace NAS 1611-010 "O" rings for D2594-3 / B61762 "O" Rings	JL	10/09/22	x8		S 10/09/22

Part No: D350-636-012 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Page 8

Work Order ID: 61568

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

103.0000

8

8



O-RING

Location

Loc Qty

Loc Code

FP

103

M115589

V8

114451

3

115460

100

AN8C21A

Purchased

No

250

Each

43.0000

2

2



BOLT

Location

Loc Qty

Loc Code

ST345

43

113558

3

114653

40

AN960C816L

NAS1149C832R

Purchased

No

250

Each

0.0000

1

2



WASHER

D2741

Manufactured

No

250

Each

14.0000

1

1



Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST466

14

57949

14

D3493-1

Manufactured

No

250

Each

34.0000

2

2



Washer

Location

Loc Qty

Loc Code

ST065

34

59127

4

60873

30

60873

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 9

Work Order ID: 61568

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3532-1 Manufactured No

250 Each

19.0000

2

2



Spacer



61673

*Handwritten signature*

Location

Loc Qty

Loc Code

ST068

19

60510

19

D3672-13 Purchased No

250 Each

828.0000

2

2



Phenolic Washer



*Handwritten signature*

Location

Loc Qty

Loc Code

ST077

828

54363

828

MS21083C8 Purchased No

250 Each

30.0000

1

2



NUT



57863

M115594

*Handwritten signature*

Location

Loc Qty

Loc Code

ST303

30

113845

7

114934

23

D2600-3-BENT Manufactured No

110 Each

9.0000

1

1



Extrusion Bent



Location

Loc Qty

Loc Code

LG

9

D2744 Manufactured No

110 Each

27.0000

1



Cap



Location

Loc Qty

Loc Code

LG

27

59198

27

*Handwritten: 59410, BE1634*

*Handwritten: 10-8-31, 10-9-2*

*Handwritten: 10-8-31, 10-9-2*

*Handwritten: BE 10-9-2*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 10

Work Order ID: 61568

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

2.0000

1

1



350 I Beam

Location

Loc Qty

Loc Code

LG

B61637

2

61256

2

①

DP 10-9-9

D2743

Manufactured No

160

Each

211.0000

8

8



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

211

50281

10

57953

2

59111

199

B 8E 10-9-14

D3490-3

Manufactured No

160

Each

47.0000

4

4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

47

60294

10

61218

37

4 8E 10-9-14

D3490-1

Manufactured No

160

Each

85.0000

4

4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

85

59424

3

61217

82

4 8E 10-9-14

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *AL568*  
*BS 10-8-30*

RELEASED

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REMOVE QTY (2) MS21083C8 REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AL</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	<i>AL</i>		
CHECKED	<i>AL</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>AL</i>	D2750	SHEET 1 OF 11
APPROVED	<i>AL</i>	TITLE	SCALE
DE APPR.	<i>AL</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

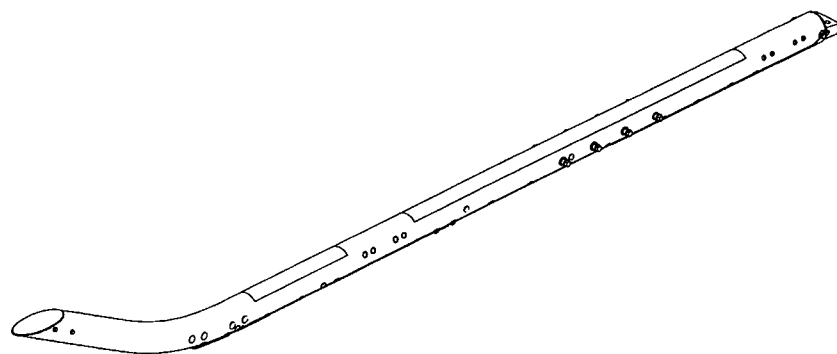
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

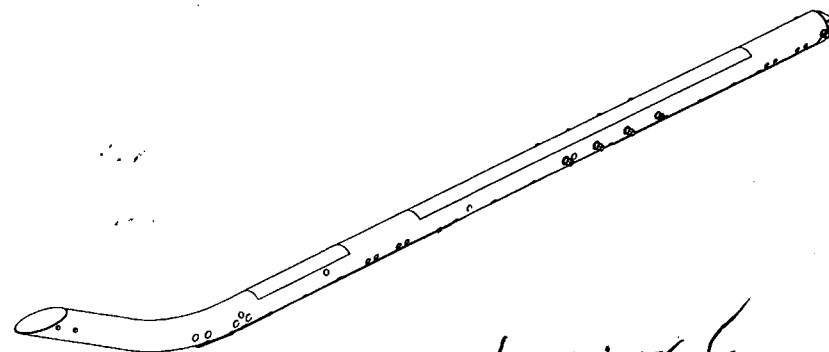
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

*wlo 61568*

**RELEASED**  
18 JUL 1994

DESIGN	PC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AM	PORT HADLOCK, WA	
CHECKED	A	DRAWING NO.	REV. F
MFG. APPR.	MA	<b>D2750</b>	SHEET 2 OF 11
APPROVED	MP	TITLE	SCALE
DE APPR.	TH	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

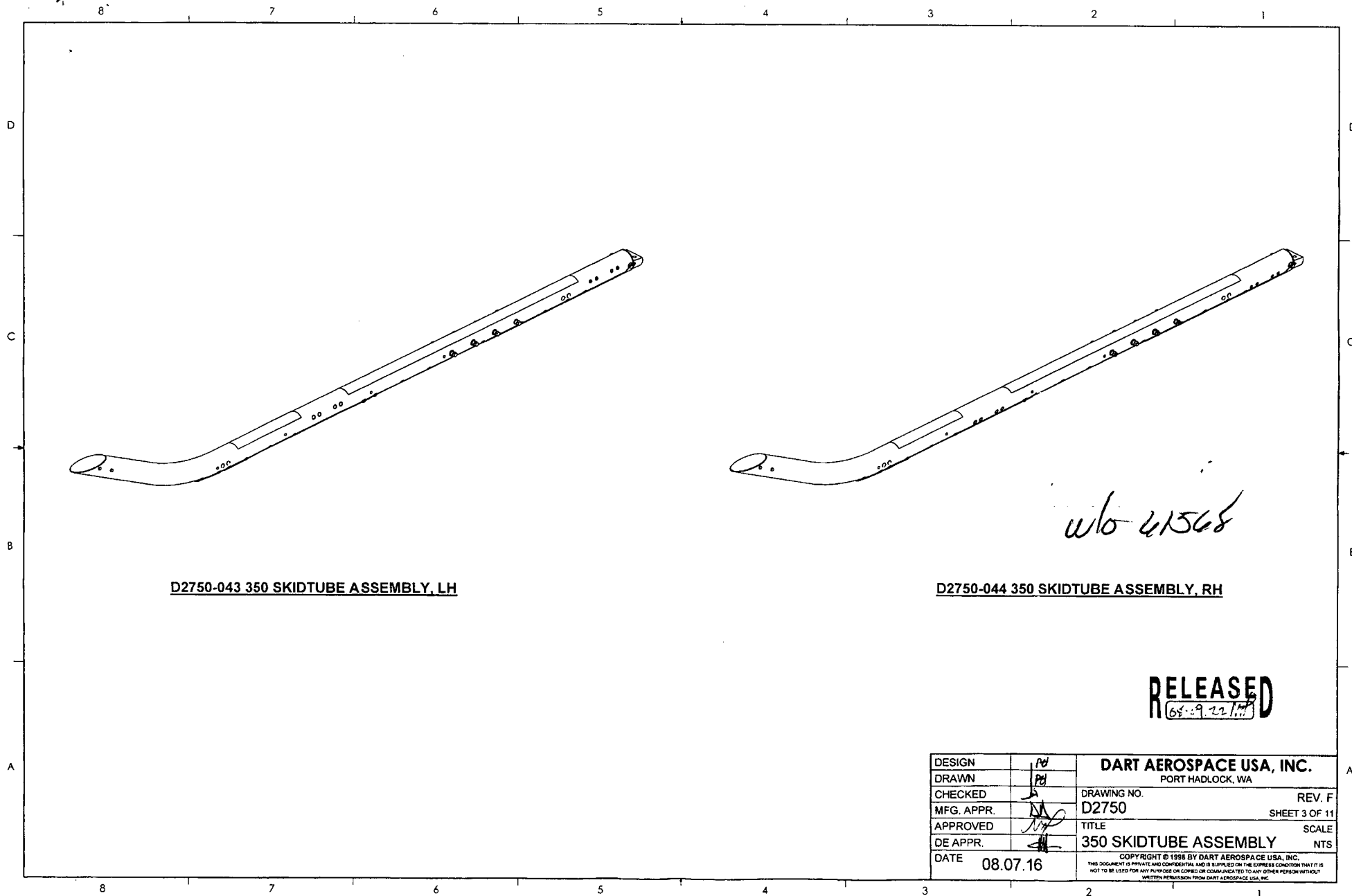
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



*w/o 41568*

**RELEASED**  
68-9-22-1-11

DESIGN	PH	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.	PH	SHEET 3 OF 11	
APPROVED	PH	TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS
DE APPR.	PH	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC.	
DATE <b>08.07.16</b>		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

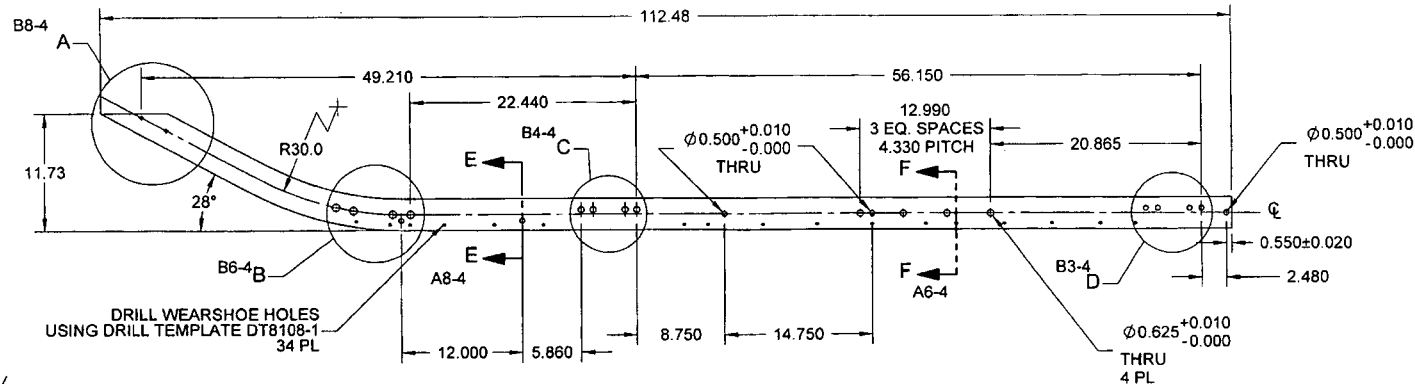
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

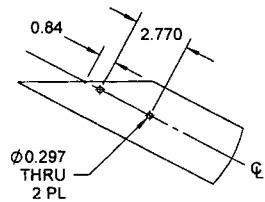
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

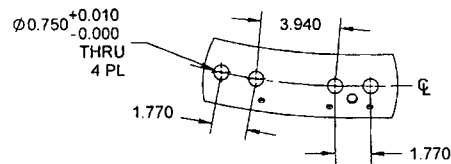
**NOTE:** Date & initial all entries



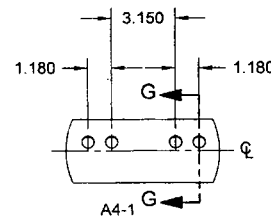
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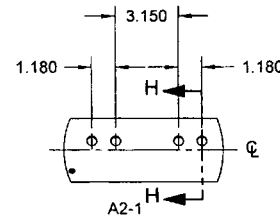
**DETAIL A**  
SCALE 2X



**DETAIL B**  
SCALE 2X

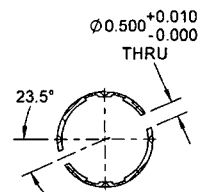


**DETAIL C**  
SCALE 2X

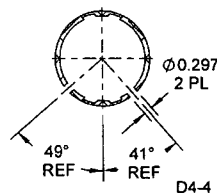


**DETAIL D**  
SCALE 2X

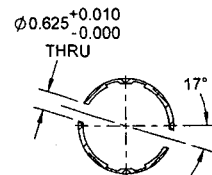
*W/C 6/15/68*



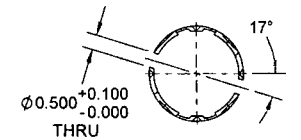
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

**RELEASED**  
08-07-16

DESIGN	IP#	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	IP#	PORT HADLOCK, WA	
CHECKED	IP#	DRAWING NO.	REV. F
MFG. APPR.	IP#	D2750	SHEET 4 OF 11
APPROVED	IP#	TITLE	SCALE
DE APPR.	IP#	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

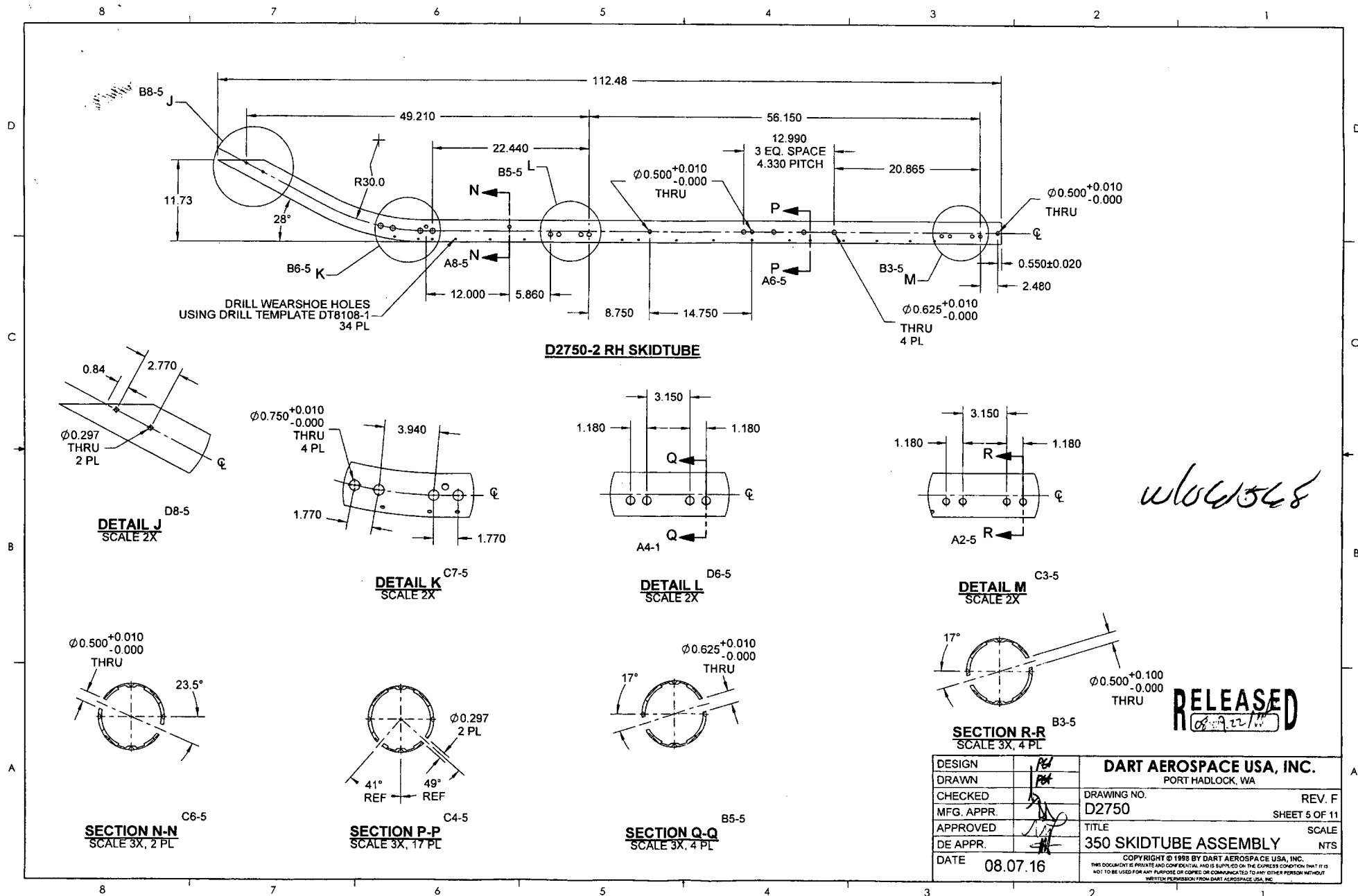
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





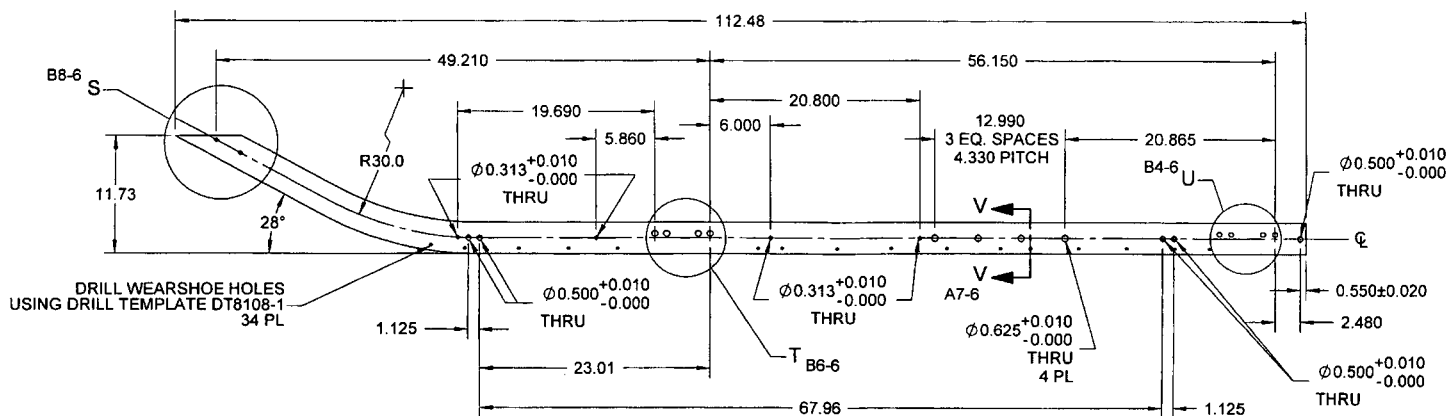
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

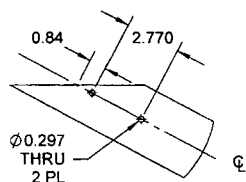
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

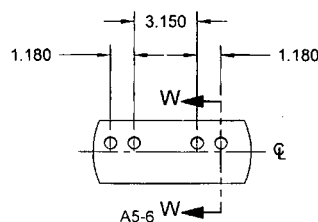
**NOTE:** Date & initial all entries



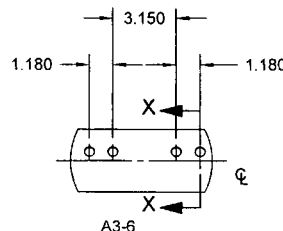
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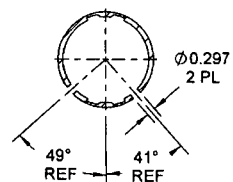
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SCALE 2X



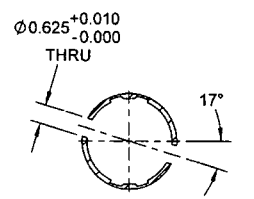
**DETAIL T**  
SCALE 2X



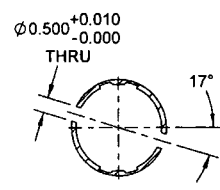
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

*u/b 61546*

**RELEASED**  
08.07.16

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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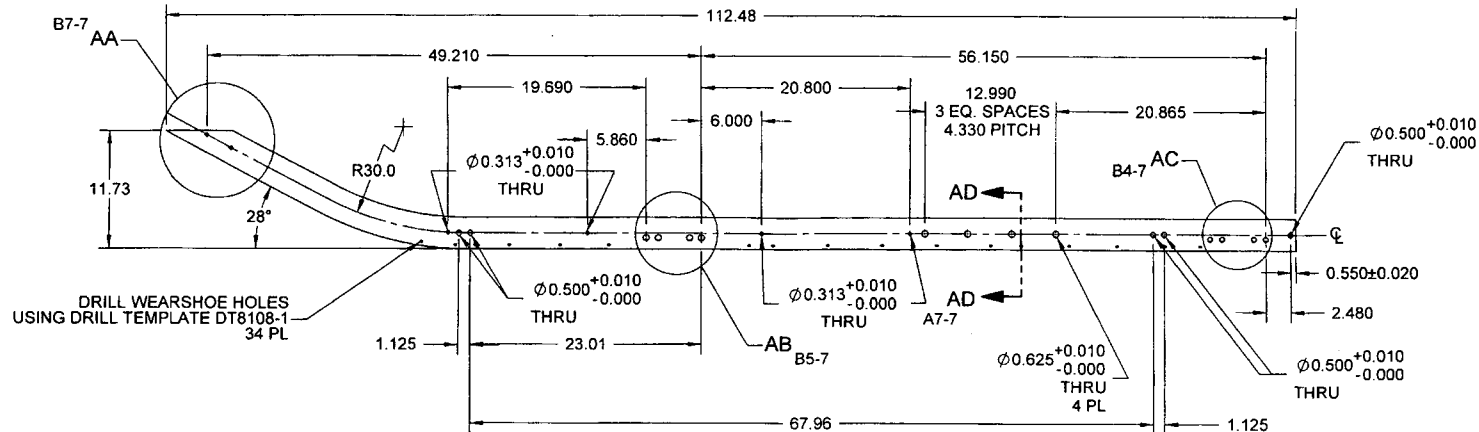
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

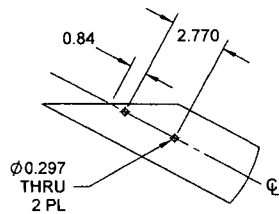
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

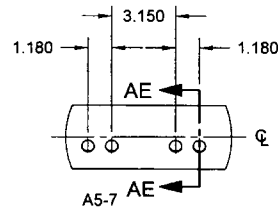
**NOTE:** Date & initial all entries



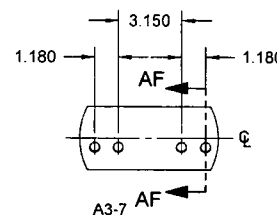
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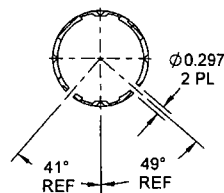
**DETAIL AA**  
SCALE 2X



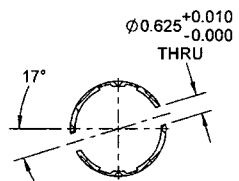
**DETAIL AB**  
SCALE 2X



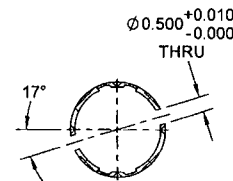
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

*w/661568*

**RELEASED**  
08-04-22

DESIGN		<b>DART AEROSPACE USA, INC.</b>
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. <b>D2750</b>
MFG. APPR.		REV. F
APPROVED		SHEET 7 OF 11
DE APPR.		TITLE <b>350 SKIDTUBE ASSEMBLY</b>
DATE	<b>08.07.16</b>	SCALE <b>NTS</b>

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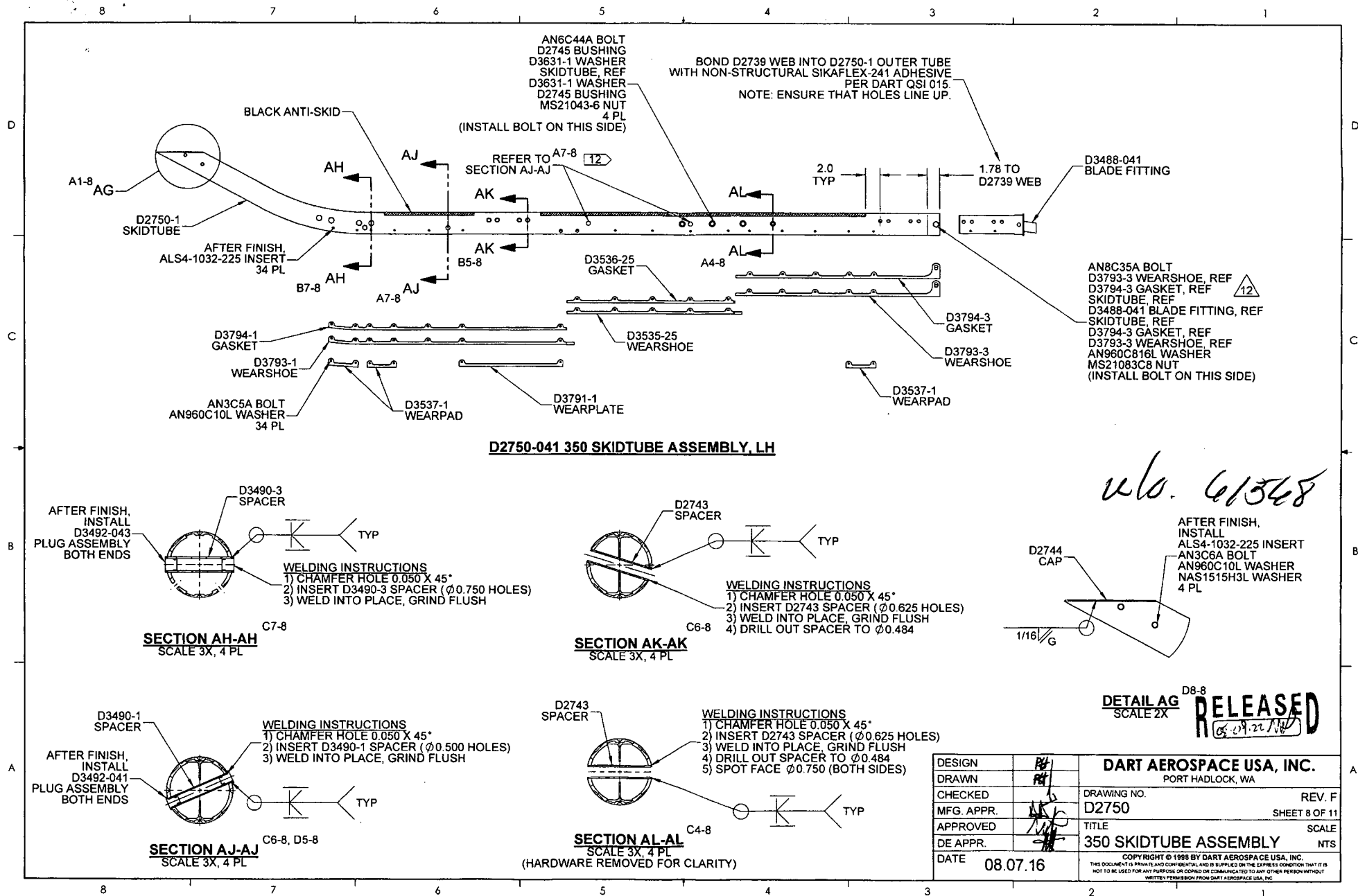
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

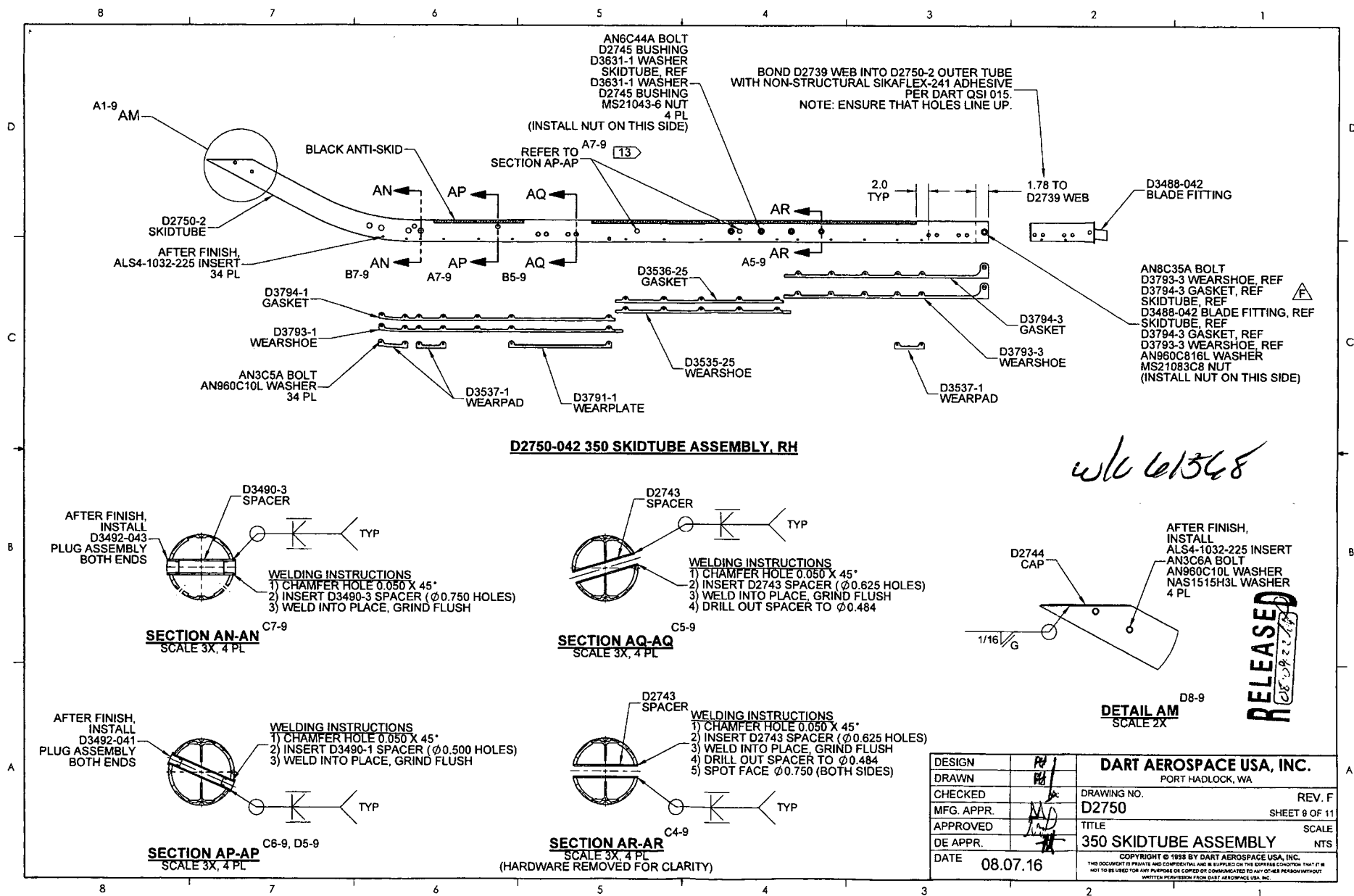
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**NOTE:** Date & initial all entries





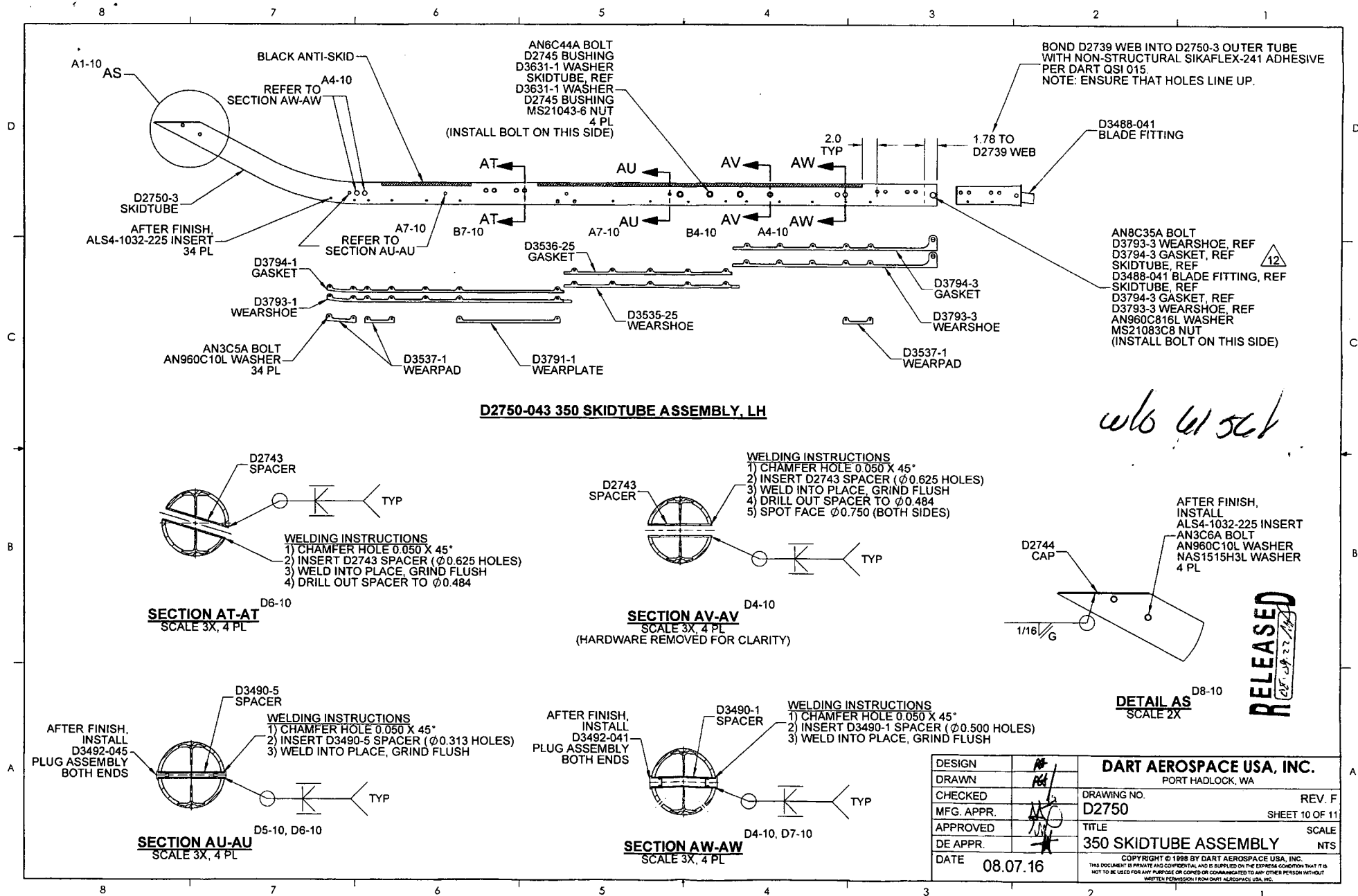
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



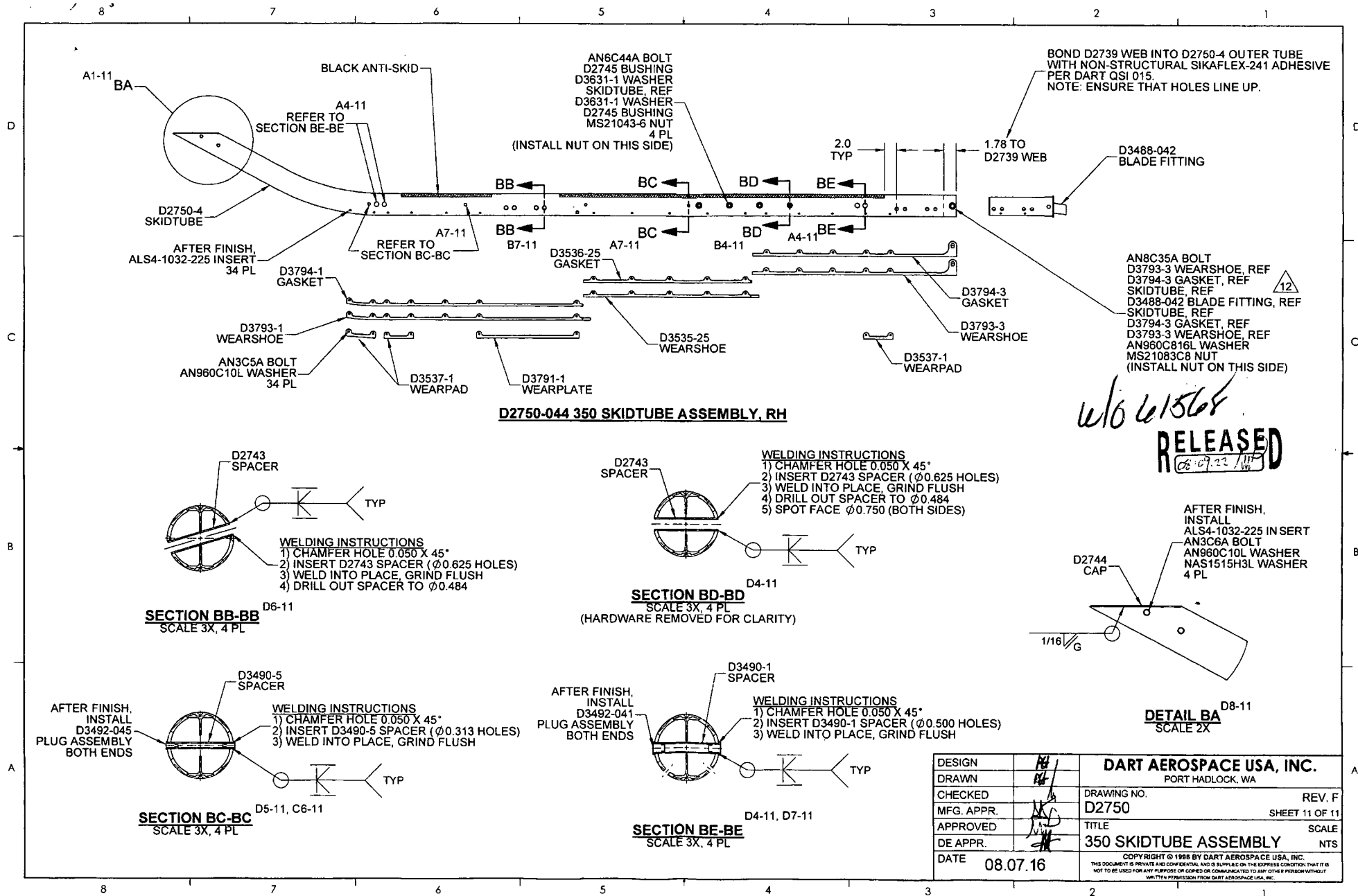
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 236

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 60988  
Part number: D350-636-012  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier [Signature] Date of Test Coupon 10.08.12

Welder [Signature] Date of Test Coupon 10.08.12

The above named individual is qualified in accordance with AWS D17.1.2001 to weld